

Work Order ID 80481

February-21-12 1:49:36 PM

80481

Page 1

Item ID: D3571-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Guide

Stop ***NS2***

Start Date: 21/02/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/02/21 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3571

Rev A

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 2.90 " long

16

0

12/03/29

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA681 Rev: AA & Dwg D3571 Rev: A 2-Deburr per dwg D3571

16

0

12/03/30

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

16

0

12/03/30

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Cust Item ID:

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

150

Powdercoat

Memo

0.00

Powder Coating

START TIME:

8h45

OVEN TEMPERATURE:

m 117 338

9h15 FINISH TIME:

320°F

16 12/04/03

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

16. BL 12-4-3.

170

Identify as per dwg & Stock Location: 245

0.00

170

Packaging

Memo

0.00

Packaging

12/4/3 (16x) 10

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MLJ 12/04/03

R 12-04-3

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Picklist Print

February-21-12 1:49:39 PM

Page 1

Work Order ID: 80481

80481

Parent Item: D3571-3

D3571-3

Parent Item Name: Guide

Start Date: 21/02/2012

Required Date: 06/03/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A New Issue 07-02-01 JLM

IPP Rev:B Remove manual Machinig 08-05-26 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X01.50 0		Purchased	No			110	f	4.4000	0.241	1.522105			

M6061T6B0 750X01 500

6061-T6 Bar .750 X 1.50

**

4.225'

12/03/29

Location

Loc Qty

Loc Code

MAT002

4.4

116604

1.5

118182

2

118844

0.786

119513

0.114

121040

0.667'

3.558'

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DART AEROSPACE LTD		Work Order:	80481
Description: Guide		Part Number:	D3571-3
Inspection Dwg: D3571	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.698	+/-0.010	0.699	✓		SLO8	Vein
2.75	+/-0.030	2.752	✓			
1.38	+/-0.030	1.377	✓			
1.25	+/-0.030	1.251	✓			
0.63	+/-0.010	0.624	✓			
0.031 chamfer	+/-0.010	0.035	✓			
Ø0.500	+0.006/-0.001	Ø0.501	✓			
Ø0.201	+0.005/-0.001	Ø0.201	✓			
R0.25	+/-0.030	R.250	✓		Rad Gauge	
0.260	+0.000/-0.010	0.253	✓		SLO8	
Ø0.385 x 100°	+0.006/-0.001 +/-0.010	0.375 x 100°	✓			
0.125	+/-0.010	0.126	✓			
2.250	+/-0.010	2.247	✓			
0.250	+/-0.010	0.250	✓			
0.188	+/-0.010	0.191	✓			
0.063 chamfer	+/-0.010	0.0585	✓			

Measured by:	SS
Date:	12/03/30

Audited by:	mf
Date:	12/04/01

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.16	New Issue	KJ/JLM	SS

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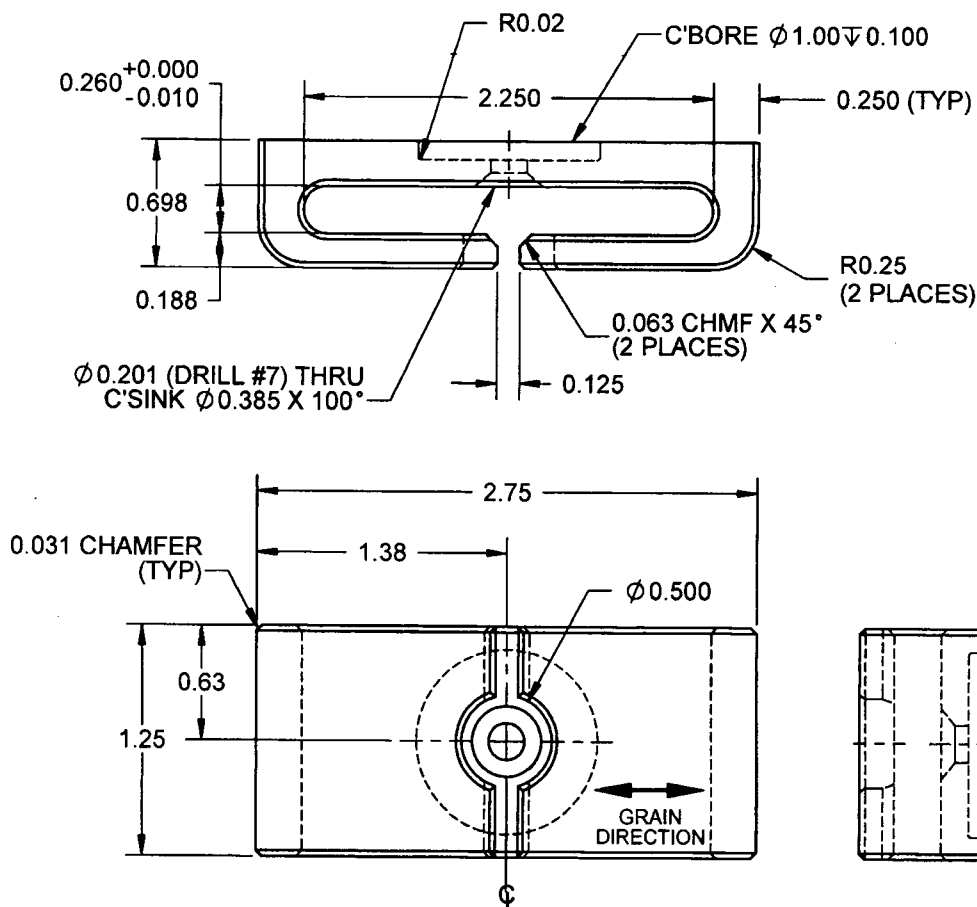
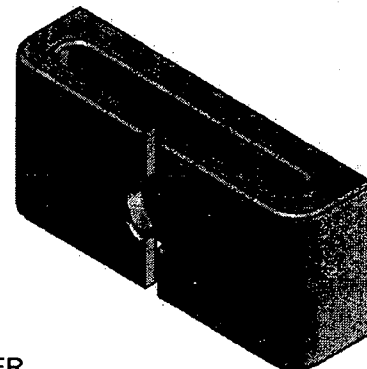
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DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3571	REV. A SHEET 1 OF 2
DATE 07.01.29	TITLE GUIDE SCALE 1:1		
REV A	DATE 07.01.29	DESCRIPTION NEW ISSUE	

RELEASED07.04.12 *[Signature]*80481MCS
12/02/21**D3571-1 GUIDE****NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT ϕ

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Dart Aerospace Ltd

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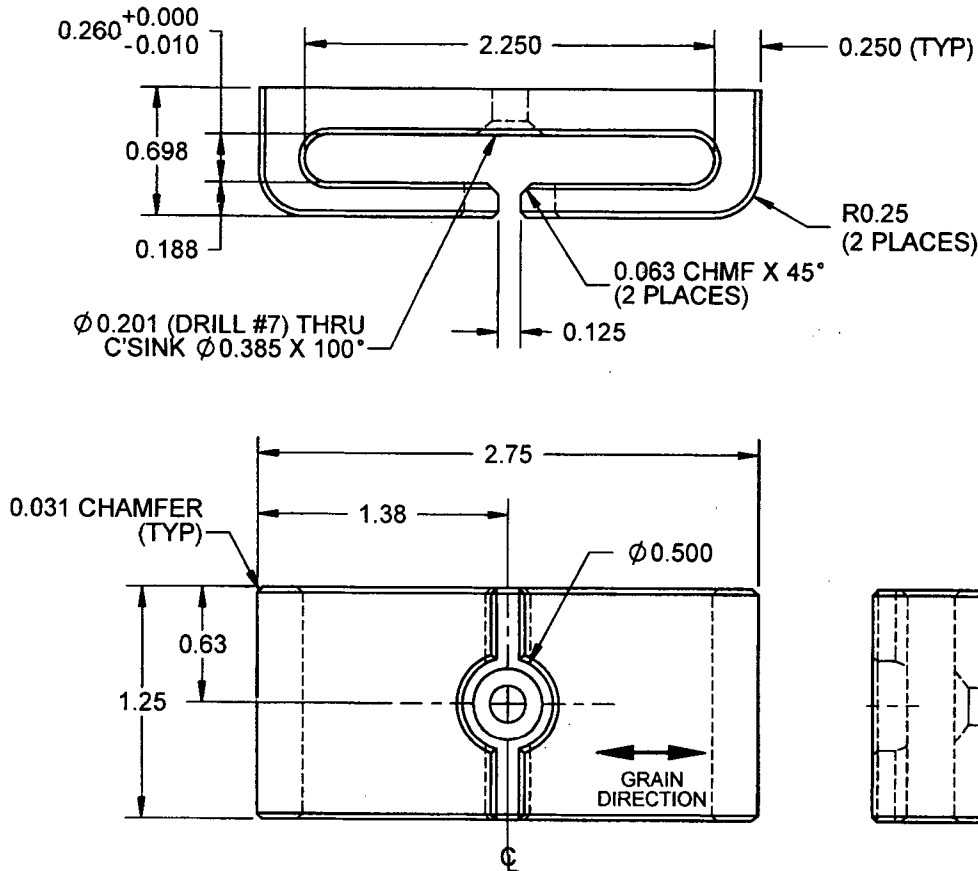
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3571	REV. A SHEET 2 OF 2
DATE 07.01.29		TITLE GUIDE	SCALE 1:1

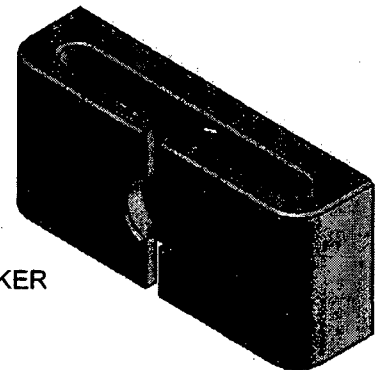
RELEASED
07.04.12 *[Signature]*



D3571-3 GUIDE

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